



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2850-2**Job Sheet 196835****Part No:** D2850-2**Job Qty:** 12 pcs**Part Name:** End Cap**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/21/19**Job Tracking No:****Due Date:** 7/10/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP B 98.12.07 Changed folio DM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	7/10/19	7/10/19	0.00	0.03	Bandsaw - 1		JML 19/07/23
110	HAAS 4 Axis - B4B	12 pcs	7/10/19	7/10/19	0.36	9.38	HAAS - 1 - B4B		JML 19/07/23
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	12 pcs	7/10/19	7/10/19	0.00	0.00	QC 8 - 12		JML 19/07/25
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
140	Packaging 3-1 - Stock - B4B	12 pcs	7/10/19	7/10/19	0.00	0.00	Packaging 3 - 1 - B4B		



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S199970**Part:** D2850-2**Job No:** 196835**Serial No/Batch:** S199970**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 07/23/19

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	12 pcs	7/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
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JUL 25 2019

JUL 26 2019

DAS
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9-89

Part Op **100** - (Bandsaw) blanks: 3.8"
 Descriptions: **110** - (HAAS CNC Vertical Machine) Machine per Folio D2850-2
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____) *** STOCK IN STEP CELL ***
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	3.8496 ft (.3208 ea)	100-Bandsaw - 1	S188591-4.16

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	4	15	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	High Float Step End Bracket	3.550inches $\pm$ 0.030	3.580 3.520		3.560
2	High Float Step End Bracket	0.189inches $\pm$ 0.010	0.199 0.179		0.191
3	High Float Step End Bracket	1.720inches + 0.000 - 0.030	1.720 1.690		1.718
4	High Float Step End Bracket	0.178inches $\pm$ 0.010	0.188 0.168		.184
5	High Float Step End Bracket	0.100inches $\pm$ 0.030	0.130 0.070		.095
6	High Float Step End Bracket	30.000Degrees $\pm$ 0.500	30.500 29.500		30.00
7	High Float Step End Bracket	2.150inches $\pm$ 0.030	2.180 2.120		2.140
8	High Float Step End Bracket	0.375inches $\pm$ 0.010	0.385 0.365		0.374
9	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115		.122
10	High Float Step End Bracket	1.000inches $\pm$ 0.030	1.030 0.970		0.997
11	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115		.125
12	High Float Step End Bracket	0.750inches $\pm$ 0.010	0.760 0.740		.748
13	High Float Step End Bracket	0.250inches $\pm$ 0.030	0.280 0.220		.250
14	High Float Step End Bracket	0.063inches $\pm$ 0.010	0.073 0.053		.063
15	High Float Step End Bracket	0.257inches + 0.006 - 0.001	0.263 0.256		.257
16	High Float Step End Bracket	0.600inches $\pm$ 0.010	0.610 0.590		.594

Plex 6/21/19 2:36 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					